

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014338**Date Inspected:** 24-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 7BE

ZPMC NWIT No: 005809

This Q.A Inspector performed Ultrasonic testing of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The member are identified as the. X8E. Designations are as follows.

SEG036D-013, 022, 031

SEG036E-065, 164, 173

ULTRASONIC INSPECTION

OBG SEGMENT 7BW

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## WELDING INSPECTION REPORT

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SEG035D-064, 173

SEG035E-013, 022, 031

This QA Inspector randomly observed the following work in progress.

### OBG SEGMENT 9AE-9BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 068764 performing Shielded Metal Arc Welding process for weld OBE9B-003 located on PCMK. Bottom panel splice weld between OBG segment 9AE and 9BE. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-b-u2-Fcm-1.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 069841 performing Shielded Metal Arc Welding process for weld OBE9B-002 located on PCMK. Side panel splice weld between OBG segment 9AE and 9BE (cross beam side). ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-b-u2-Fcm-1.

### OBG SEGMENT 8AW

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067183 performing Shielded Metal Arc Welding process for weld OBW8-021 located on PCMK. Counter weight connection plate. ZPMC QC Mr. Cai Xiao Feng monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-u2-FCM-1.

### OBG SEGMENT 8AE-8BE

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 053609 performing Flux Cored Arc Welding process for weld SEG046B-100 located on PCMK. Weld between longitudinal diaphragms to bottom panel. ZPMC QC Mr. Liu Hua Jie monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-1G (1F)-Repair.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer